

Wednesday, April 04, 2012 1:42:03 PM

Page 1

Setup Start *NS1*

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

100		0.00	
100	BAND SAW		
Bandsaw			
	Memo	0.00	FK 12/04/15 24 0
Jeaspa Bandsaw	Cut blanks: (0.75" x 0.75") x 5.75" Long Bar		

110	HAAS CNC VERTICAL MACHINING #1	0.00	
110			
HAAS 1	Memo	0.00	24 10
HAAS CNC vertical machine #1	1- Machine as per Folio D2324-3 and Dwg D23242- Deburr and Tumble to remove sharp edges Identify as D2324-3		SL 12/04/19
120	QC2- Inspect parts off machine FAI/FAIB	0.00	
120			
QC	Memo	0.00	24 10
Quality Control			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 82676***82676***

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Item ID: D2324-3 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bar
Start Date: 4/9/2012 Start Qty: 24.00 *24* Cust Item ID:
Required Date: 4/16/2012 Req'd Qty: 24.00 *24* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
160									
Packaging	Memo	0.00				24			12/04/20
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							MLJ 12/04/20
Quality Control									

12-04-20

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Picklist Print

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Page 1

Work Order ID: 82676

Parent Item: D2324-3

Parent Item Name: Bar

Start Date: 4/9/2012

Required Date: 4/16/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP: E03.02.28Reformat; Incorporated D2324-3 & D2324-5KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.750 6061-T6 Bar .750 x .750		Purchased	No			100	f	24.6200	0.53	13.389474			

Location

Loc Qty

Loc Code

MAT002

8.58

114993

4.58

119346

4

MAT003

16.04

119801

16.04

~~13.39~~

F.K. 12/04/15

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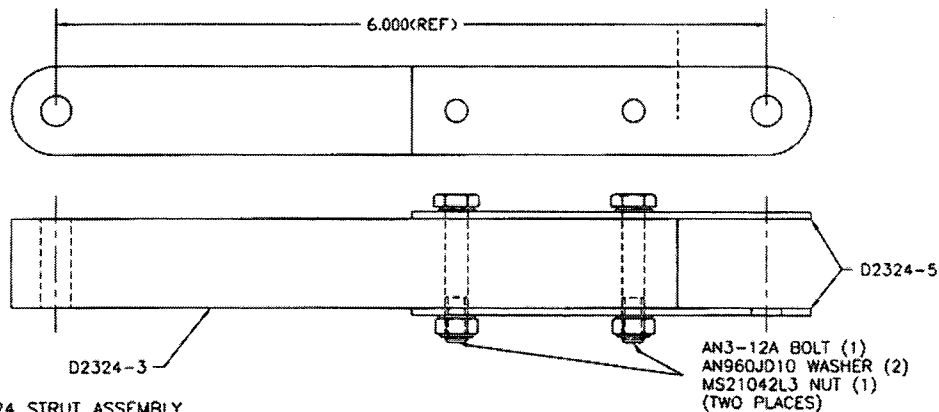
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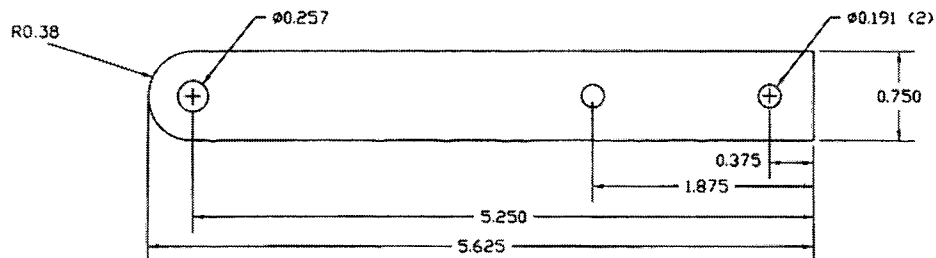
DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		STRUT	
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED
04.12.16 *[Signature]*



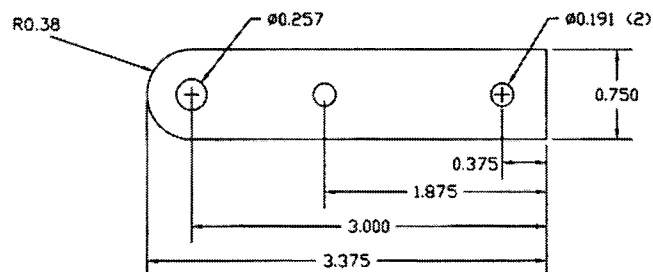
D2324 STRUT ASSEMBLY

- 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

82676

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